

Date: Monday, 1/22/2007 7:43:32 AM
 User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BEARPAW KIT (19"X16") |
| Job Number : 30337 | |
| Estimate Number : 12613 | |
| P.O. Number : <i>N/A</i> | Part Number : D120638011 |
| This Issue : 1/22/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2435 REV E1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : MACHINED PARTS | Drawing Revision : E1 |
| Previous Run : <i>N/A</i> | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 2/12/2007 Qty: 5 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.01.22 | |
| Comment : Est Rev:A New Issue 07-01-02 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Photocopy bluefile:

and create labels per PPPD120-638-011 CHG 002

(Bag Bluefiles separately)

(5)

Kg 07.01.25

| | | |
|-----|----------|---------------|
| 2.0 | MUHMWB10 | UHMW 1" Black |
|-----|----------|---------------|



Comment: Qty.: 4.5491 sf(s)/Unit Total : 22.7456 sf(s)
 blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: *M103428*

J.L 07/02/09

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|

**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

J.L/J.F. 07/02/10

(5)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*J.L/J.F. 07/02/10*

(5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30337

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.02.12

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 8.3300 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

628042 ✓

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2435(ref only) Bearpaw

628713 ✓
30327

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp

628732 ✓

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

128733 ✓

EP 04/02/12 (5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/02/13

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30337

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M103444 ✓

12.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416

Washer

M101938 ✓

13.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M19185 ✓

Boz/02/12 (5)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Boz/02/13 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD120638011

Location: Draft

Boz/02/13 (5) 10

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Boz/02/13

Job Completion



W 07.02.13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|---|--|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 30337 |
| Description: Bearpaw | | Part Number: | D2435 |
| Inspection Dwg: D2435 Rev: E1 | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A | 0.063 x 45° | +0.030/-0.010 | .065x45° | ✓ | | | |
| B | 5.500 | +/-0.030 | 5.500 | ✓ | | | |
| C | 0.200 | +/-0.030 | .197 | ✓ | | | |
| D | R0.250 | +/-0.030 | .250 | ✓ | | | |
| E | 0.250 | +/-0.010 | .257 | ✓ | | | |
| F | 0.625 | +/-0.030 | .630 | ✓ | | | |
| G | 0.25 x 45° | +/-0.030 | .255x45° | ✓ | | | |
| H | 0.375 | +/-0.010 | .377 | ✓ | | | |
| I | 19.000 | +/-0.030 | 19.00 | ✓ | | | |
| J | 0.950 | +0.030/-0.010 | .955 | ✓ | | | |
| K | Ø0.260 | +0.005/-0.000 | .261 | ✓ | | | |
| L | Ø0.930 | +/-0.030 | .931 | ✓ | | | |
| M | 0.30 | +0.030/-0.000 | .320 | ✓ | | | |
| N | 0.375 | +/-0.030 | .375 | ✓ | | | |
| O | 7.375 | +/-0.030 | 7.376 | ✓ | | | |
| P | 4.250 | +/-0.010 | 4.251 | ✓ | | | |
| Q | 2.000 | +/-0.030 | 2.020 | ✓ | | | |
| R | 9.000 | +/-0.010 | 9.001 | ✓ | | | |
| S | 15.750 | +/-0.030 | 15.750 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |

| | |
|---------------------|----------|
| Measured by: | J.L |
| Date: | 07/02/08 |

| | |
|--------------------|----------|
| Audited by: | MS |
| Date: | 07/02/09 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------|------------|----------|
| A | 03.09.22 | New Issue P/O K10007 | KJ/RF | ✱ |



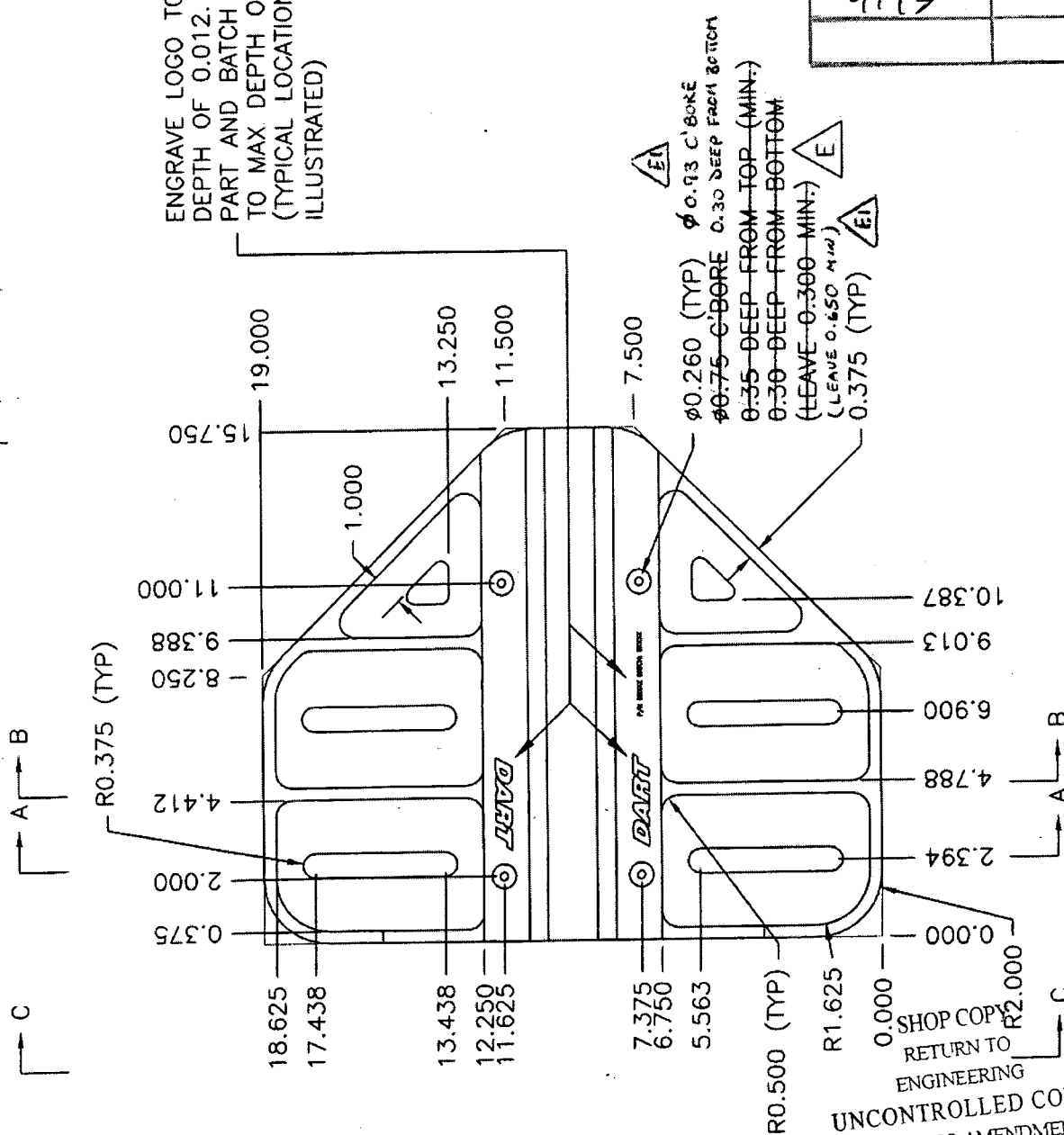
| | | | | | |
|---------|----------|---------------------------------|---------|---|--------------|
| DESIGN | KE | DRAWN BY | KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MB | APPROVED | DS | DRAWING NO. | REV. E |
| | | | | D2435 | SHEET 1 OF 2 |
| DATE | 98.05.19 | TITLE | BEARPAW | SCALE | 1:5 |
| A | 96.01.24 | NEW ISSUE | | | |
| B | 96.03.26 | CHANGE BORE AND C'BORE DEPTH | | | |
| C | 97.05.07 | CHANNEL & C'BORE DEPTH CHANGED | | | |
| D | 97.10.17 | R1.5 BORE WAS R2.637 (TSR A469) | | | |
| E | 98.05.19 | CHANGE C'BORE, R1.58 WAS R1.50 | | | |

EFFECTIVE DEOS

| | |
|------|--|
| 9143 | |
| | |

RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



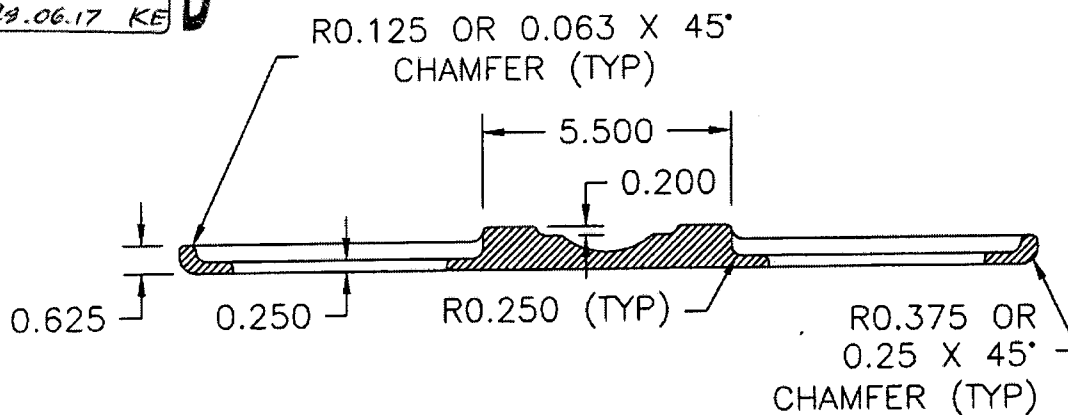
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30337

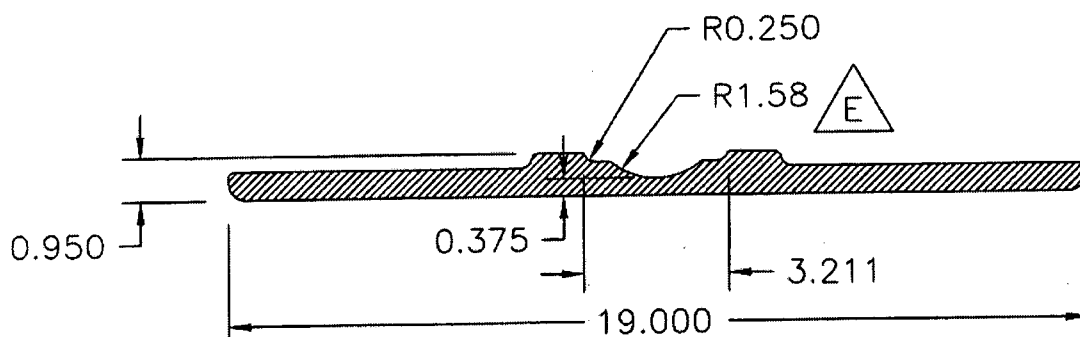


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2435 | REV. E SHEET 2 OF 2 |
| DATE 98.05.19 | TITLE BEARPAW | | SCALE 1:4 |

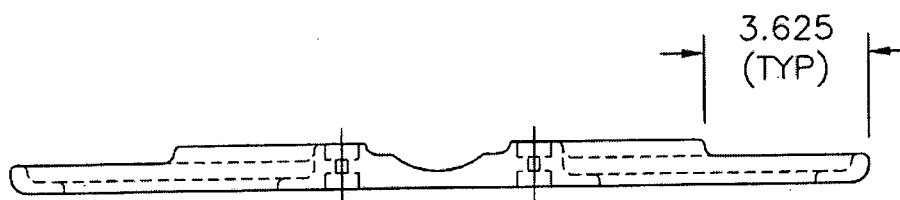
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30337